

Date: Monday, 1/7/2008 3:38:03 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING BRACKET
Job Number : 36617	
Estimate Number : 11964	
P.O. Number :	Part Number : D2052
This Issue : 1/7/2008 S.O. No. :	Drawing Number : D2052 REV <i>B/C</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : <i>10/10/08</i>
Previous Run : 35363	Material :
Written By :	Due Date : 1/31/2008 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est C 01.08.21 Added Finishing SM (Issue this IPP with part number D2053) Est Rev D now water jet 07-10-25 DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S090	5052-H32 .090 Sheet
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*6*



Comment: Qty.: 0.1355 sf(s)/Unit Total : 5.4180 sf(s)  
Material: 5052-H32, 0.090" Thick  
(M5052H3S.090)  
Batch: *3019* *IB 8-1-14*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D2052  
Dwg Rev: *C* *IB 8-1-14*  
Prog Rev: *C*

2-Deburr if necessary

*[Signature]* *08/01/15* *(43)*

*(43)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*IB 8-1-14*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*[Signature]* *08/01/16* *(43)* *counter*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
Form as per Dwg D2053 using CNC Brake

*IB 08/01/14* *(43)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 08/01/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:03 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

Job Number: 36617

Part Number: D2052

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*ccs*  
08/01/16 (48)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005

*HP* 08-01-21 (48)

8.0

POWDER COATING

POWDER COATING



*M100700*



(48X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref 4.3.5.8) as per QSI 005 4.3

*M-1* 08/01/24

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*FX* 08/01/24 (48)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5752*

*12/8/01/28* (48)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*2008/01/29* (48)

Job Completion



*2008/1/28* (43X)

*W*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

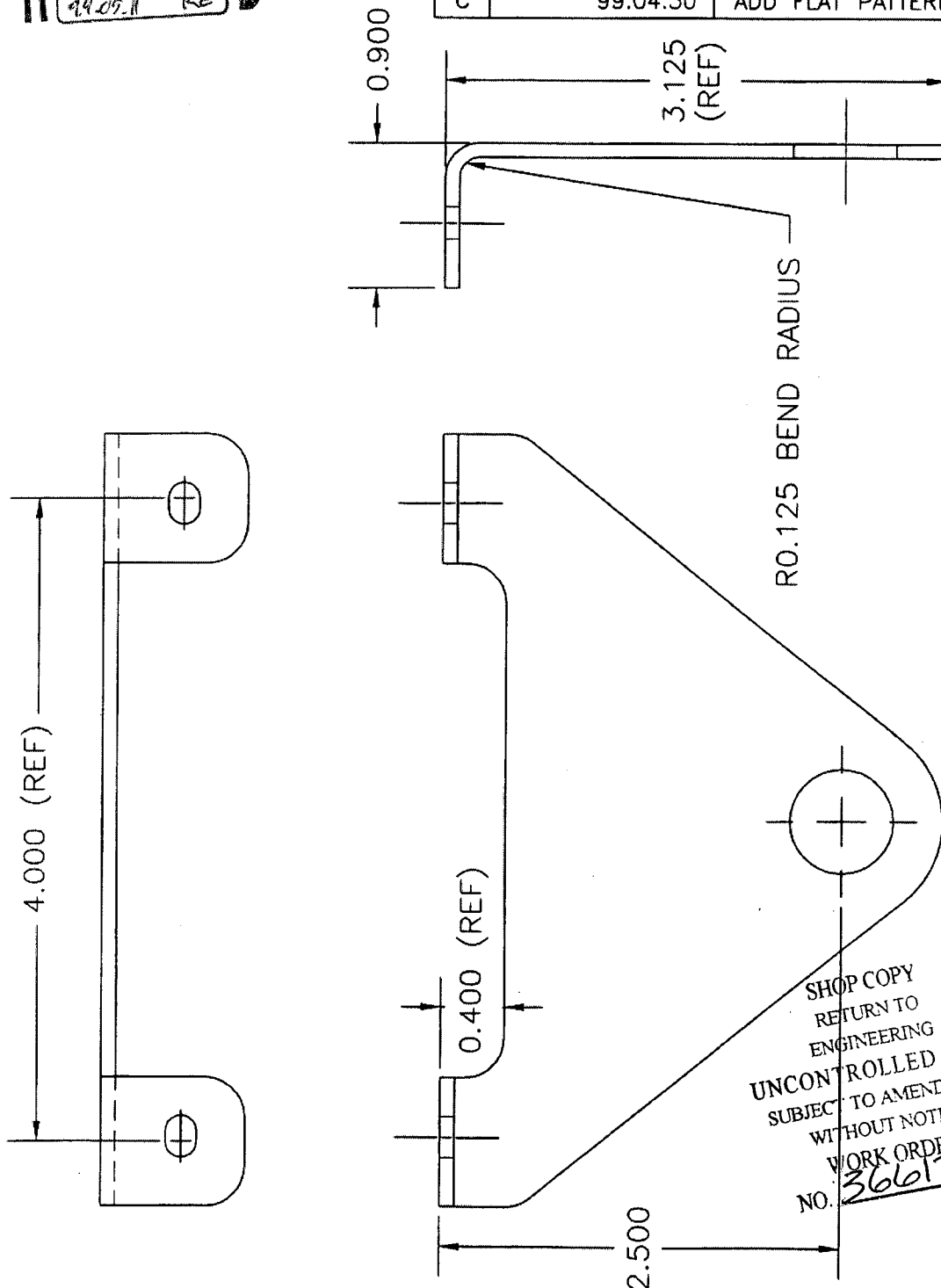
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED MF	DRAWING NO. D2052	REV. C SHEET 1 OF 2
DATE 99.04.30	TITLE BRACKET		SCALE 1:1
A	92.01.12	NEW ISSUE	
B	97.02.21	ADD SLOT TO FOOT	
C	99.04.30	ADD FLAT PATTERN	

RELEASED  
99.05.11 KE



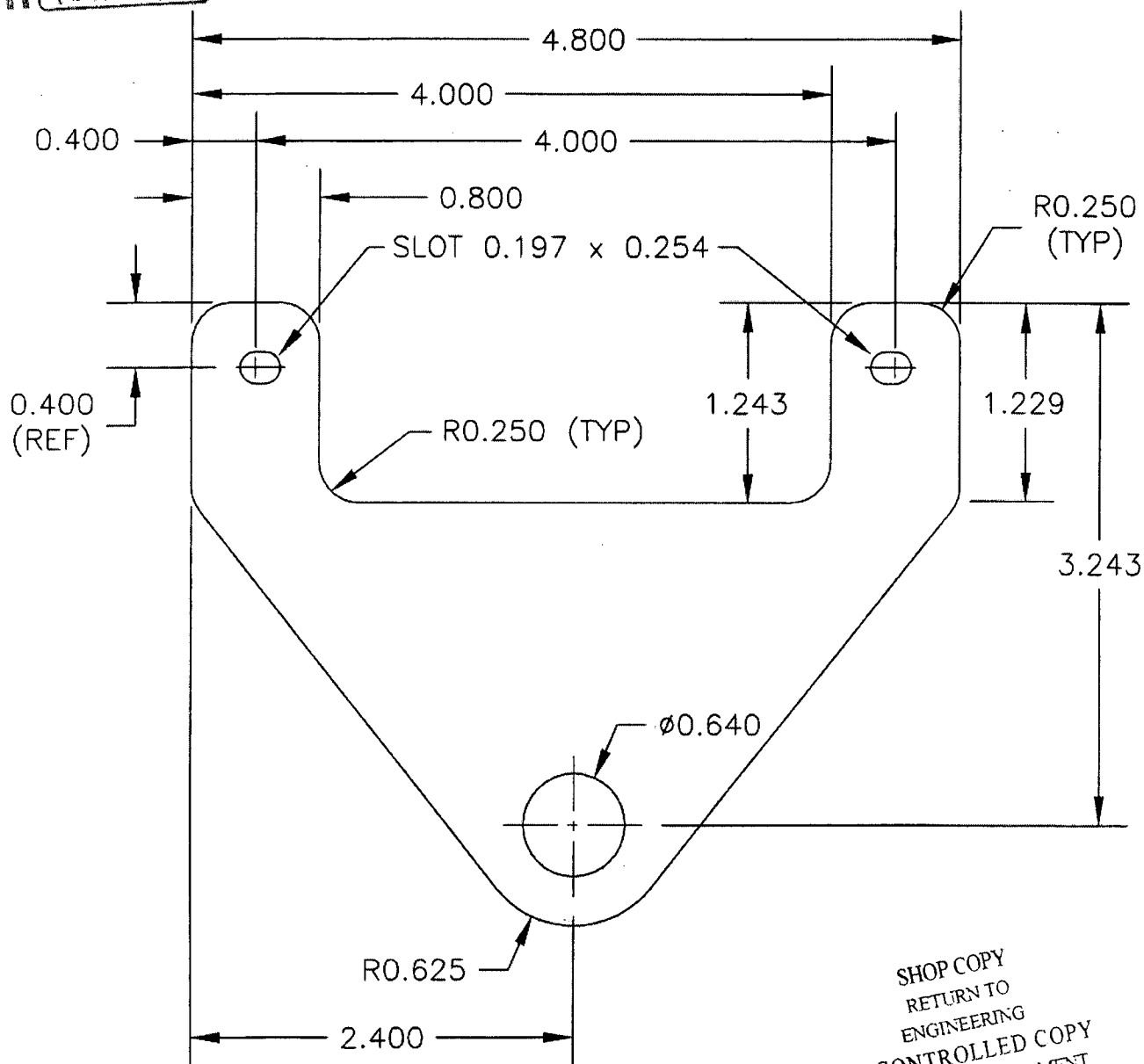
SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36617

MATERIAL: 5052-H32 (QQ-A-250/8), 0.090 THICK  
FINISH: POWDER COAT CRINKLE BLACK (4.3.5.3) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2052	REV. C SHEET 2 OF 2
DATE 99.04.30	TITLE BRACKET		SCALE 1:1

RELEASED  
99.05.11 KE



D2052 FLAT PATTERN

MATERIAL: 5052-H32 (QQ-A-250/8), 0.090 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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